

Use of alkenyl-functional siloxane copolymers as
antimisting additives in crosslinkable silicone coating
compositions

5

The invention relates to the use of antimisting additives for reducing the formation of aerosol in crosslinkable silicone coating compositions.

10 A trend within the silicone coating industry is to increase machine speed in order to raise productivity. Where silicone coatings are applied to the substrate at relatively high speeds, of more than 300 m/min, for example, fine spray mists of the silicone coating system
15 may be formed. This aerosol is formed at the silicone applicator unit. The formation of this spray mist proves to be a serious problem in the context of further increases in the coating speed.

20 The formation of this spray mist can be reduced by adding what are known as antimisting additives to the silicone coating system.

EP-A 716 115 (Dow Corning Corp.) describes antimisting
25 additives obtained by reacting an organosilicon compound, a compound containing oxyalkylene groups, and a catalyst. The addition of these oxyalkylene-functional reaction products to crosslinkable silicone coating systems reduces the formation of aerosol in rapid coating
30 processes.

WO 01/98420 (Dow Corning Corp.) discloses a liquid silicone antimisting composition, which is obtained by reacting
35 a) an organohydropolysiloxane having at least two Si-H groups (SiH) with

- b) an organoalkenylsiloxane having at least three alkenyl groups (C=C) in
- c) the presence of a platinum catalyst and if desired
- d) an inhibitor

5 in a ratio of C=C/SiH \geq 4.6.

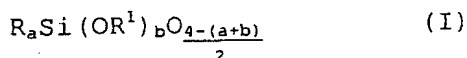
An extremely large excess of organoalkenylsiloxane (C=C) is necessary in order to prevent gelling. This excess influences the release properties of the base system, the crosslinkable silicone coating composition. Furthermore,
10 an inhibitor has to be added to prevent gelling.

US-A 5,241,034 (Wacker-Chemie GmbH) describes alkenyl functional siloxane copolymers which are branched and whose organopolysiloxane blocks are linked by hydrocarbon
15 bridges.

The object was to provide antimisting additives for silicone coating compositions which reduce the formation of aerosol in rapid coating processes, which are readily
20 miscible with the silicone coating compositions, and which do not impair the silicone coating compositions. This object is achieved by the invention.

The invention provides for the use of antimisting additives in crosslinkable silicone coating compositions for reducing the formation of aerosol, characterized in that as antimisting additives alkenyl-functional siloxane copolymers containing

30 (a) siloxane units of the formula



where R is identical or different, unhalogenated or halogenated hydrocarbon radicals having from 1 to 18

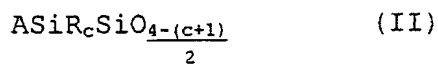
carbon atoms per radical,
 R^1 is identical or different alkyl radicals having
 from 1 to 4 carbon atoms per radical, which may be
 substituted by an ether oxygen atom,

5 a is 0, 1, 2 or 3,

b is 0, 1, 2 or 3

and the sum $a+b$ is not greater than 3,

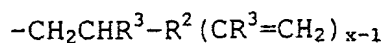
10 (b) per molecule at least one siloxane unit of the
 formula



where R is as defined above,

c is 0, 1 or 2,

A is a radical of the formula



15 where R^2 is a divalent, trivalent or tetravalent
 hydrocarbon radical having from 1 to 25 carbon atoms
 per radical,

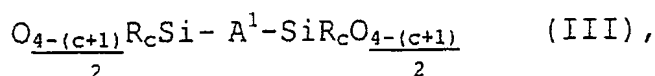
R^3 is a hydrogen atom or an alkyl radical having from
 1 to 6 carbon atoms per radical, and

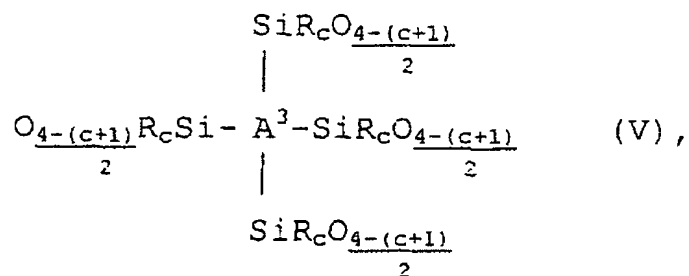
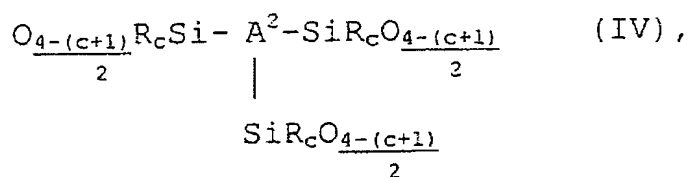
20 x is 2, 3 or 4,

and

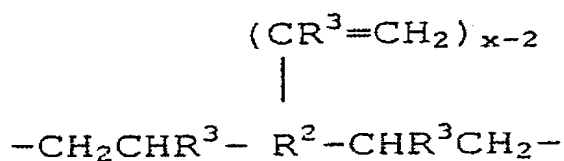
(c) per molecule on average at least one unit selected
 from the group consisting of units of the formulae
 where R and c are as defined above,

25



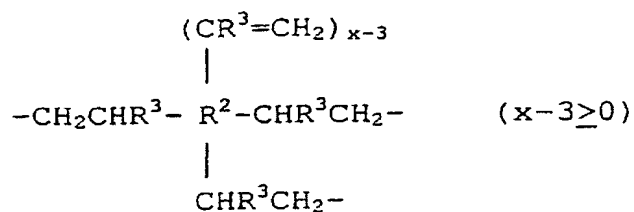


A¹ is a radical of the formula



where R², R³ and x are as defined above,

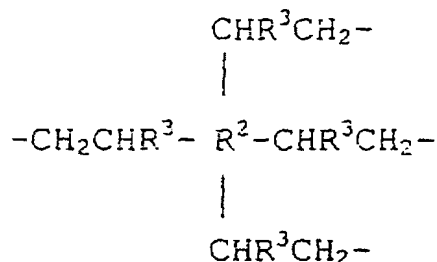
5 A² is a radical of the formula



where R², R³ and x are as defined above, with the proviso that R² is not a divalent hydrocarbon

radical, and

A³ is a radical of the formula



5 where R² and R³ are as defined above, with
the proviso that R² is not a divalent or
trivalent hydrocarbon radical.

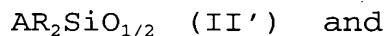
10 Preferred alkenyl-functional siloxane copolymers are
those containing

(a) siloxane units of the formula



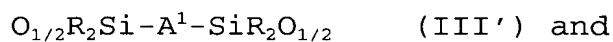
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(b) per molecule on average more than one siloxane unit
of the formula

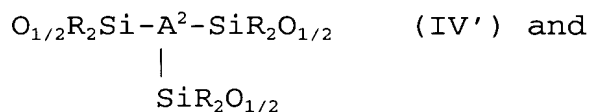


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(c) per molecule on average at least one unit selected
from the group consisting of units of the formulae



25

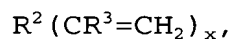


where R, A, A¹ and A² are as defined above.

With particular preference the alkenyl-functional
5 siloxane copolymers contain per molecule on average at
least two siloxane units of the formula (II').

The invention also provides for the use of antimisting
additives in crosslinkable silicone coating compositions
10 for reducing the formation of aerosol, which comprises
using as antimisting additives alkenyl-functional
siloxane copolymers preparable

by reacting organic compound (1) containing at least two
15 aliphatic double bonds, of the general formula



where R² is a divalent, trivalent or tetravalent
20 hydrocarbon radical having from 1 to 25 carbon atoms per
radical,

R³ is a hydrogen atom or an alkyl radical having from 1 to
6 carbon atoms per radical, and
x is 2, 3 or 4

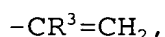
25 with organopolysiloxane (2) having on average more than
one Si-bonded hydrogen atom per molecule
in the presence of catalyst (3) which promotes the
addition of Si-bonded hydrogen onto aliphatic double
bond,

30 the ratio of aliphatic double bond in organic compound
(1) to Si-bonded hydrogen in the organopolysiloxane (2)
being such that alkenyl-functional siloxane copolymers
having on average more than one alkenyl group per
molecule, of the formula

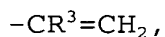


where R³ is as defined above, are obtained.

In the process according to the invention, alkenyl-
functional siloxane copolymers having on average at least
5 four alkenyl groups per molecule, of the formula



preferably on average at least eight alkenyl groups per
10 molecule, of the formula



15 where R³ is as defined above,
are preferably obtained.

The alkenyl-functional siloxane copolymers and their
preparation are described in the above-cited US-A
20 5,241,034, and US-A-5,241,034 (incorporated by reference)
is therefore part of the disclosure content of this
specification.

The antimisting additives of the invention, the alkenyl-
25 functional siloxane copolymers, have the advantage that
they not only reduce the formation of aerosol by
crosslinkable silicone coating compositions in rapid
coating systems but also, in particular, can be mixed in
any desired proportions, homogeneously, with the
30 crosslinkable silicone coating compositions, unlike the
antimisting additives containing polyglycol groups from
the above-cited EP-A 716 115.

Moreover, the antimisting additives of the invention have
35 no inhibiting effect and they are storage-stable.
The antimisting additives according to the invention have

the advantage that they can be mixed beforehand with the polymer component (A) of the crosslinkable silicone coating composition. They are consequently easy to handle and do not impair the release properties of the base system, the crosslinkable silicone coating composition.

The alkenyl-functional siloxane copolymers of the invention preferably possess a viscosity of from 500 to 5 000 000 mPa.s at 25°C, more preferably from 1000 to 1 000 000 mPa.s at 25°C.

In the alkenyl-functional siloxane copolymers according to the invention the siloxane blocks are joined to one another via hydrocarbon groups, resulting in a hydrocarbon-siloxane block structure. Preferably the sum of the hydrocarbon groups A, A¹, A² and A³ in the alkenyl-functional siloxane copolymers is from 0.1 to 10% by weight, more preferably from 0.1 to 2% by weight, based in each case on the total weight of the alkenyl-functional siloxane copolymers.

The polyaddition process of the invention results automatically in a polymer distribution in respect of the siloxane blocks and of the hydrocarbon blocks. A "polyadduct" of this kind usually also contains lower oligomers, which also include adducts consisting only of one siloxane block and two hydrocarbon blocks.

Examples of radicals R are alkyl radicals, such as the methyl, ethyl, n-propyl, isopropyl, 1-n-butyl, 2-n-butyl, isobutyl, tert-butyl, n-pentyl, isopentyl, neopentyl, tert-pentyl radical; hexyl radicals, such as the n-hexyl radical; heptyl radicals, such as the n-heptyl radical; octyl radicals, such as the n-octyl radical and isooctyl radicals, such as the 2,2,4-trimethylpentyl radical; nonyl radicals, such as the n-nonyl radical, decyl

radicals, such as the n-decyl radical; dodecyl radicals, such as the n-dodecyl radical; octadecyl radicals, such as the n-octadecyl radical; cycloalkyl radicals, such as cyclopentyl, cyclohexyl, cycloheptyl radicals and methylcyclohexyl radicals; aryl radicals, such as the phenyl, naphthyl, anthryl and phenanthryl radical; alkaryl radicals, such as o-, m-, p-tolyl radicals, xylyl radicals and ethylphenyl radicals and aralkyl radicals, such as the benzyl radical, the α - and the β -phenylethyl radical. The methyl radical is preferred.

Examples of halogenated radicals R are haloalkyl radicals, such as the 3,3,3-trifluoro-n-propyl radical, the 2,2,2,2',2',2'-hexafluoroisopropyl radical, the heptafluoroisopropyl radical and haloaryl radicals, such as the o-, m-, and p-chlorophenyl radical.

Examples of alkyl radicals R^1 are the methyl, ethyl, n-propyl, isopropyl, 1-n-butyl, 2-n-butyl, isobutyl and tert-butyl radical. The methyl and ethyl radicals are preferred. Examples of alkyl radicals R^1 which are substituted by an ether oxygen atom are the methoxyethyl and ethoxyethyl radical.

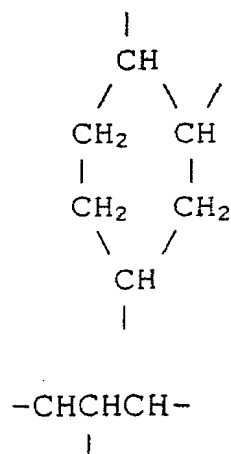
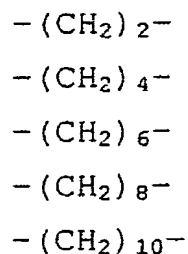
Examples of alkyl radicals R^3 are the methyl, ethyl, n-propyl, isopropyl, 1-n-butyl, 2-n-butyl, isobutyl, tert-butyl, n-pentyl, isopentyl, neopentyl, tert-pentyl radical, and hexyl radicals, such as the n-hexyl radical. R^3 is preferably a hydrogen atom.

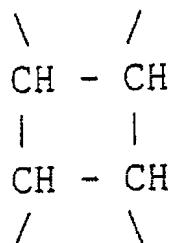
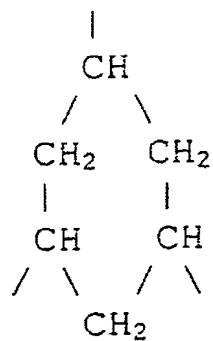
Examples of organic compound (1) containing at least two aliphatic double bonds which is used in the process according to the invention are

1,5-hexadiene,
1,7-octadiene,

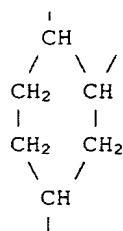
- 1,9-decadiene,
 1,11-dodecadiene,
 1,13-tetradecadiene,
 3,5-dimethyl-1,6-heptadiene,
 5 3,5-dimethyl-4-vinyl-1,6-heptadiene,
 1,2,4-trivinylcyclohexane,
 1,3,5-trivinylcyclohexane,
 1,4-divinylbenzene and
 1,2,3,4-tetravinylcyclobutane,
 10
 preference being given to 1,2,4-trivinylcyclohexane and
 1,5-hexadiene.

Examples of the radical R^2 are therefore those of the
 15 formula

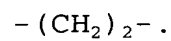




5 preference being given to the radicals of the formula



and



10

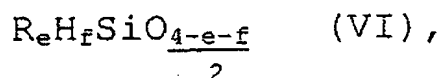
The organopolysiloxanes (2) used in the process according

to the invention preferably contain on average at least 1.5 Si-bonded hydrogen atoms, more preferably on average at least two Si-bonded hydrogen atoms per molecule.

- 5 With particular preference the organopolysiloxanes (2) used in the process according to the invention contain from two to four Si-bonded hydrogen atoms per molecule.

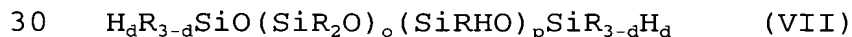
10 In the process according to the invention it is possible to use one kind of organopolysiloxane (2) or different kinds of organopolysiloxane (2). As a result of their preparation the organopolysiloxanes (2) are also mixtures; in other words, for example, organopolysiloxanes having two Si-bonded hydrogen atoms
15 per molecule also contain organopolysiloxanes having only one Si-bonded hydrogen atom per molecule.

As organopolysiloxanes (2) it is preferred to use those of the general formula
20



where R is as defined above,
e is 0 or 1, on average from 0.005 to 1.0,
f is 0, 1, 2 or 3, on average from 1.0 to 2.0, and
the sum e+f is not greater than 3,
25 in the process according to the invention.

As organopolysiloxanes (2) it is more preferred to use those of the general formula



where R is as defined above,

d is 0 or 1,
o is 0 or an integer from 1 to 1000, and
p is 0 or an integer from 1 to 6,
in the process according to the invention.

5

The organopolysiloxanes (2) preferably possess a viscosity of from 50 to 20 000 mPa.s at 25°C, more preferably from 500 to 10 000 mPa.s at 25°C.

10 Preferred examples of organopolysiloxanes of the formula (VII) are copolymers of dimethylhydrosiloxane and dimethylsiloxane units, copolymers of dimethylhydrosiloxane, dimethylsiloxane and methylhydrosiloxane units, copolymers of trimethylsiloxane and methyl-
15 hydrosiloxane units, and copolymers of trimethylsiloxane, dimethylsiloxane, and methylhydrosiloxane units.

Processes for preparing organopolysiloxanes having at least two Si-bonded hydrogen atoms per molecule,
20 including those of the preferred kind, are general knowledge.

In the case of the process according to the invention it is preferred to use as organic compound (I) 1,2,4-
25 trivinylcyclohexane and as organopolysiloxane (2) a siloxane of the general formula



where R is as defined above and
o is an integer from 50 to 1000.

30

Organic compound (1) is used in the process according to the invention in amounts such that the ratio employed of

aliphatic double bond in organic compound (1) to Si-bonded hydrogen in organopolysiloxane (2) is preferably from 1.1:1 to 20:1, more preferably from 1.5:1 to 10:1, very preferably from 1.5:1 to 5:1, in particular from 1.5:1 to 3.0:1.

As catalysts which promote the addition of Si-bonded hydrogen onto aliphatic multiple bond it is possible in the process of the invention as well to use the same catalysts which it has also been possible to date to use for promoting the addition of Si-bonded hydrogen onto aliphatic multiple bond. The catalysts are preferably a metal from the group of the platinum metals or a compound or a complex from the group of the platinum metals. Examples of such catalysts are metallic and finely divided platinum, which may be on supports, such as silica, alumina or activated carbon, compounds or complexes of platinum, such as platinum halides, e.g., PtCl_4 , $\text{H}_2\text{PtCl}_6 \cdot 6\text{H}_2\text{O}$, $\text{Na}_2\text{PtCl}_4 \cdot 4\text{H}_2\text{O}$, platinum-olefin complexes, platinum-alcohol complexes, platinum-alkoxide complexes, platinum-ether complexes, platinum-aldehyde complexes, platinum-ketone complexes, including reaction products of $\text{H}_2\text{PtCl}_6 \cdot 6\text{H}_2\text{O}$ and cyclohexanone, platinum-vinylsiloxane complexes, such as platinum-1,3-divinyl-1,1,3,3-tetramethyldisiloxane complexes with or without a detectable inorganically bonded halogen content, bis(gamma-picoline)platinum dichloride, trimethylenedipyridineplatinum dichloride, dicyclopentadieneplatinum dichloride, dimethyl-sulfoxide-ethyleneplatinum(II) dichloride, cyclooctadieneplatinum dichloride, norbornadieneplatinum dichloride, gamma-picolineplatinum dichloride, cyclopentadieneplatinum dichloride, and reaction products of platinum tetrachloride with olefin and primary amine or secondary amine or primary and secondary amine, such as the reaction product of platinum tetrachloride dissolved in

1-octene with sec-butylamine or ammonium-platinum complexes.

5 The catalyst (3) is used preferably in amounts of from 0.5 to 1000 ppm by weight (parts by weight per million parts by weight), more preferably in amounts of from 2 to 50 ppm by weight, calculated in each case as elemental platinum and based on the overall weight of organic compound (1) and organopolysiloxane (2).

10

The process according to the invention is preferably conducted at the pressure of the surrounding atmosphere, i.e., approximately at 1020 hPa (abs.), but may also be conducted at higher or lower pressures. Furthermore, the
15 process according to the invention is conducted preferably at a temperature of from 20°C to 150°C, more preferably from 20°C to 80°C.

Since the organic compound (1) containing at least two
20 aliphatic double bonds, e.g., 1,2,4-trivinylcyclohexane, tends toward polymerization at relatively high temperatures, it is possible in the process according to the invention to use radical inhibitors, such as 4-methoxyphenol, 2,6-bis(tert-butyl)-4-methylphenol,
25 phenothiazine, hydroquinone or pyrocatechol. The radical inhibitors are used preferably in amounts of from 10 to 500 ppm by weight, based on the overall weight of organic compound (1) and organopolysiloxane (2).

30 In the process according to the invention it is possible to use inert organic solvents, although the use of inert organic solvents is not preferred. Examples of inert organic solvents are toluene, xylene, octane isomers, butyl acetate, 1,2-dimethoxyethane, tetrahydrofuran, and
35 cyclohexane.

The alkenyl-functional siloxane copolymers prepared according to the process according to the invention preferably have their excess organic compound (1) and also any inert organic solvent used removed by
5 distillation.

Alternatively to organic solvents it is possible to use inert silicone oils in the process according to the invention or to trade the organic solvent for such oils
10 after the preparation of the branched siloxane copolymers of the invention.

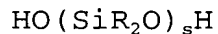
For greater ease of handling it is also possible to trade organic solvents for reactive silicone oils after the preparation of the branched siloxane copolymers of the
15 invention, by adding such oils to the reaction mixture and then removing the solvent by distillation. Preference is given to silicone oils having a viscosity of 100 mm²/s at 25°C and SiC-bonded alkenyl radicals as reactive constituent.

20 The alkenyl-functional siloxane copolymers prepared according to the process according to the invention are optionally equilibrated with organopolysiloxane (4).

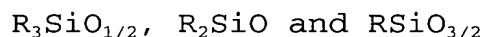
25 As organopolysiloxanes (4) it is preferred to use those selected from the group consisting of preferably linear organopolysiloxanes containing terminal triorganosiloxy groups, of the formula



where R is as defined above and
r is 0 or an integer whose value is preferably from 1 to 1500, more preferably from 10 to 300,
35 linear organopolysiloxanes containing terminal hydroxyl groups, of the formula

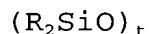


where R is as defined above and
s is an integer whose value is preferably from 1 to 1500,
5 more preferably from 10 to 300,
branched organopolysiloxanes optionally containing
hydroxyl groups, comprising units of the formula



10

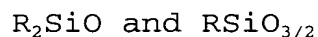
where R is as defined above,
cyclic organopolysiloxanes of the formula



15

where R is as defined above and
t is an integer from 3 to 12,
and copolymers comprising units of the formula

20



where R is as defined above.

Preferred organopolysiloxanes (4) are preferably those of
25 the formulae $\text{R}_3\text{SiO}(\text{SiR}_2\text{O})_r\text{SiR}_3$, $\text{HO}(\text{SiR}_2\text{O})_s\text{H}$ and $(\text{R}_2\text{SiO})_t$,
particular preference being given to those of the formula
 $\text{R}_3\text{SiO}(\text{SiR}_2\text{O})_r\text{SiR}_3$.

The proportion of the organopolysiloxanes (4) used in the
30 optional equilibration and alkenyl-functional siloxane
copolymers is determined merely by the desired fraction
of the alkenyl groups in the siloxane copolymers produced
in the course of the optional equilibration, and by the
desired average chain length.

35

In the course of the optional equilibration, it is

preferred to use basic or acidic catalysts which promote the equilibration. Examples of basic catalysts are preferably alkali metal hydroxides, such as sodium hydroxide, potassium hydroxide, and cesium hydroxide, 5 trimethylbenzylammonium hydroxide, and tetramethylammonium hydroxide. Alkali metal hydroxides are preferred. Alkali metal hydroxides are used preferably in amounts of from 50 to 10 000 ppm by weight (= parts per million), in particular from 500 to 2000 ppm 10 by weight, based in each case on the overall weight of the alkenyl-functional siloxane copolymers and organopolysiloxanes (4) used.

Examples of acidic catalysts are preferably sulfuric 15 acid, phosphoric acid, trifluoromethanoic acid, phosphorus nitride chlorides, and acidic catalysts which are solid under the reaction conditions, such as acid-activated bleaching earth, acidic zeolites, sulfonated charcoal, and sulfonated styrene-divinylbenzene 20 copolymer. Phosphorus nitride chlorides are preferred. Phosphorus nitride chlorides are used preferably in amounts of from 5 to 1000 ppm by weight (= parts per million), in particular from 50 to 200 ppm by weight, based in each case on the overall weight of the 25 organosilicon compounds used.

The optional equilibration is conducted preferably at from 100°C to 150°C and under the pressure of the surrounding atmosphere, i.e., approximately at 1020 hPa 30 (abs.). If desired, however, it is also possible to employ higher or lower pressures. The equilibration is preferably conducted in from 5 to 20% by weight, based on the overall weight of the respective alkenyl-functional siloxane copolymers and organopolysiloxanes (4) used, in 35 water-immiscible solvent, such as toluene. The catalyst can be deactivated before the equilibration mixture is

worked up.

The process of the invention can be conducted batchwise, semicontinuously or fully continuously.

5

As antimisting additives it is preferred to use those alkenyl-functional siloxane copolymers which are prepared without a further equilibration step and have a particularly high level of branching. Preferred additives
10 are obtained from operating in the particularly preferred stoichiometric ranges indicated.

For reducing the formation of aerosol the antimisting additives of the invention are added to the crosslinkable
15 silicone coating compositions.

The antimisting additives of the invention, the alkenyl-functional siloxane copolymers, are used in the crosslinkable silicone coating compositions preferably in
20 amounts of from 0.5 to 10% by weight, more preferably from 1 to 5% by weight, based on the overall weight of the crosslinkable silicone coating compositions.

As crosslinkable silicone coating compositions it is
25 preferred to use those comprising

- (A) organosilicon compounds having radicals containing aliphatic carbon-carbon multiple bonds,
- (B) organosilicon compounds containing Si-bonded hydrogen atoms,
- 30 (C) catalysts which promote the addition of Si-bonded hydrogen onto aliphatic multiple bond,
and if desired
- (D) inhibitors.

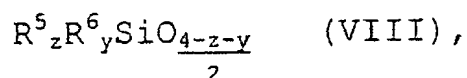
35 The invention further provides crosslinkable silicone coating compositions featuring reduced aerosol formation,

comprising

- (X) antimisting additives of the invention,
- (A) organosilicon compounds having radicals containing aliphatic carbon-carbon multiple bonds,
- 5 (B) organosilicon compounds containing Si-bonded hydrogen atoms,
- (C) catalysts which promote the addition of Si-bonded hydrogen onto aliphatic multiple bond,
- and if desired
- 10 (D) inhibitors.

For the crosslinkable silicone coating compositions it is possible with preference to use one kind of the antimisting additive (X) of the invention or different
15 kinds of the antimisting additive (X) of the invention.

As organopolysiloxanes (A) having radicals containing aliphatic carbon-carbon multiple bonds it is preferred to use linear or branched organopolysiloxanes comprising
20 units of the general formula



where R^5 is a monovalent, unsubstituted or substituted, hydrocarbon radical having from 1 to 18 carbon atoms per
25 radical and being free from aliphatic carbon-carbon multiple bonds

and

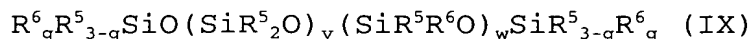
R^6 is a monovalent hydrocarbon radical having from 2 to 8 carbon atoms per radical and containing a terminal
30 aliphatic carbon-carbon multiple bond,

z is 0, 1, 2 or 3,

y is 0, 1 or 2

and the sum $z+y$ is 0, 1, 2 or 3,
with the proviso that there are on average at least 1.5
radicals R^6 , preferably on average at least 2 radicals R^6 .

- 5 Preferred organosilicon compounds (A) are
organopolysiloxanes of the general formula



- 10 where R^5 and R^6 are as defined above,
 g is 0, 1 or 2,
 v is 0 or an integer from 1 to 1500, and
 w is 0 or an integer from 1 to 200,
with the proviso that on average at least 1.5 radicals R^6 ,
15 preferably on average at least 2 radicals R^6 , are present.

- In the context of this invention formula (IX) is to be
understood to mean that v units $-(SiR^5_2O)-$ and w units $-(SiR^5R^6O)-$ may be distributed arbitrarily in the
20 organopolysiloxane molecule.

- As organosilicon compounds (A) it is also possible to use
branched polymers containing terminal ω -alkenyl groups,
preferably Si-bonded vinyl groups, as described in US
25 6,034,225 (incorporated by reference), especially column
1 line 43 to column 2 line 13, and US 6,258,913
(incorporated by reference), especially column 1 line 62
to column 2 line 35.

- As organosilicon compounds (A) it is also possible to use
30 linear organopolysiloxanes as described in US 6,274,692
(incorporated by reference), especially column 2 lines 3
to 27, which do not have an aliphatically unsaturated
hydrocarbon radical, such as an Si-bonded vinyl group, at
both ends but instead also have aliphatically saturated
35 hydrocarbon radicals, such as Si-bonded methyl groups, at
the ends.

As organosilicon compounds (A) it is also possible to use those as described in DE-A 195 22 144 (incorporated by reference), especially page 2 lines 44 to 67, DE-A 196 29 053 (incorporated by reference), especially page 2 line 51 to page 3 line 29, US-A 5,760,145 (incorporated by reference), especially column 2 line 46 to column 4 line 23 and US-A 6,265,497 (incorporated by reference), especially column 2 lines 3 to 47.

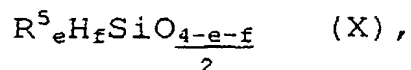
10 The organopolysiloxanes (A) preferably possess an average viscosity of from 100 to 10 000 mPa.s at 25°C.

Examples of hydrocarbon radicals R^5 are alkyl radicals, such as the methyl, ethyl, n-propyl, isopropyl, n-butyl, isobutyl, tert-butyl, n-pentyl, isopentyl, neopentyl, tert-pentyl radical, hexyl radicals, such as the n-hexyl radical, heptyl radicals, such as the n-heptyl radical, octyl radicals, such as the n-octyl radical and isooctyl radicals, such as the 2,2,4-trimethylpentyl radical, nonyl radicals, such as the n-nonyl radical, decyl radicals, such as the n-decyl radical, dodecyl radicals, such as the n-dodecyl radical, and octadecyl radicals, such as the n-octadecyl radical; cycloalkyl radicals, such as cyclopentyl, cyclohexyl, cycloheptyl radicals and methylcyclohexyl radicals, aryl radicals, such as the phenyl, naphthyl, anthryl and phenanthryl radical; alkaryl radicals, such as o-, m-, p-tolyl radicals, xylyl radicals and ethylphenyl radicals, and aralkyl radicals, such as the benzyl radical, the α - and the β -phenylethyl radical.

30 Examples of radicals R^6 are alkenyl radicals, such as the vinyl, 5-hexenyl, allyl, 3-butenyl and 4-pentenyl radical; and alkynyl radicals, such as the ethynyl, propargyl and 1-propyne radical.

35 As organosilicon compounds (B) which contain Si-bonded

hydrogen atoms it is preferred to use linear, cyclic or branched organopolysiloxanes comprising units of the general formula



5 where

R^5 is as defined above,

e is 0, 1, 2 or 3,

f is 0, 1 or 2

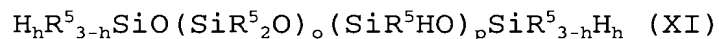
and the sum of e+f is 0, 1, 2 or 3,

10 with the proviso that there are on average at least two Si-bonded hydrogen atoms.

The organosilicon compounds (B) preferably contain at least three Si-bonded hydrogen atoms.

15

As organosilicon compounds (B) it is more preferred to use organopolysiloxanes of the general formula



20

where R^5 is as defined above,

h is 0, 1 or 2,

o is 0 or an integer from 1 to 1500, and

p is 0 or an integer from 1 to 200,

25 with the proviso that there are on average at least 2 Si-bonded hydrogen atoms.

In the context of this invention formula (XI) is to be understood to mean that o units $-(SiR^5_2O)-$ and p units $-(SiR^5HO)-$ may be distributed arbitrarily in the organopolysiloxane molecule.

30

Examples of such organopolysiloxanes are, in particular, copolymers comprising dimethylhydrosiloxane, methylhydrosiloxane, dimethylsiloxane and trimethylsiloxane units, copolymers comprising
5 trimethylsiloxane, dimethylhydrosiloxane and methylhydrosiloxane units, copolymers comprising trimethylsiloxane, dimethylsiloxane and methylhydrosiloxane units, copolymers comprising methylhydrosiloxane and trimethylsiloxane units,
10 copolymers comprising methylhydrosiloxane, diphenylsiloxane and trimethylsiloxane units, copolymers comprising methylhydrosiloxane, dimethylhydrosiloxane and diphenylsiloxane units, copolymers comprising methylhydrosiloxane, phenylmethylsiloxane,
15 trimethylsiloxane and/or dimethylhydrosiloxane units, copolymers comprising methylhydrosiloxane, dimethylsiloxane, diphenylsiloxane, trimethylsiloxane and/or dimethylhydrosiloxane units, and copolymers comprising dimethylhydrosiloxane, trimethylsiloxane,
20 phenylhydrosiloxane, dimethylsiloxane and/or phenylmethylsiloxane units.

As organosilicon compounds (B) it is also possible to use those as described in US-A 5,691,435 (incorporated by
25 reference), especially column 3 line 45 to column 4 line 29.

The organopolysiloxanes (B) preferably possess an average viscosity of from 10 to 1 000 mPa.s at 25°C.

30 Organosilicon compound (B) is used preferably in amounts of from 0.5 to 3.5, more preferably from 1.0 to 3.0, gram atoms of Si-bonded hydrogen per mole of Si-bonded radical containing aliphatic carbon-carbon multiple bond in the
35 organosilicon compound (A).

In the case of the crosslinkable silicone coating compositions as well it is possible, as catalysts which promote the addition of Si-bonded hydrogen onto aliphatic multiple bonds, to use the same catalysts which it has
5 also been possible to use to date to promote the addition of Si-bonded hydrogen onto aliphatic multiple bond. As constituent (C) it is preferred to use the abovementioned catalysts (3).

10 The catalysts (C) are used preferably in amounts of from 10 to 1000 ppm by weight (parts by weight per million parts by weight), more preferably from 50 to 200 ppm by weight, calculated in each case as elemental platinum metal and based on the overall weight of the organosilicon
15 compounds (A) and (B).

The crosslinkable silicone coating compositions may comprise agents which retard the addition of Si-bonded hydrogen onto aliphatic multiple bond at room temperature,
20 known as inhibitors (D).

For the crosslinkable silicone coating compositions as well it is possible as inhibitors (D) to use all inhibitors which it has also been possible to use to date
25 for the same purpose.

Examples of inhibitors (D) are 1,3-divinyl-1,1,3,3-tetramethyldisiloxane, benzotriazole, dialkylformamides, alkylthioureas, methyl ethyl ketoxime, organic compounds
30 or organosilicon compounds having a boiling point of at least 25°C at 1012 mbar (abs.) and containing at least one aliphatic triple bond, such as 1-ethynylcyclohexan-1-ol, 2-methyl-3-butyn-2-ol, 3-methyl-1-pentyn-3-ol, 2,5-dimethyl-3-hexyne-2,5-diol and 3,5-dimethyl-1-hexyn-3-ol,
35 3,7-dimethyloct-1-yn-6-en-3-ol, a mixture of diallyl maleate and vinyl acetate, maleic monoesters, and

inhibitors such as the compound of the formula
 $\text{HC}\equiv\text{C}-\text{C}(\text{CH}_3)(\text{OH})-\text{CH}_2-\text{CH}_2-\text{CH}=\text{C}(\text{CH}_3)_2$, available commercially
under the trade name "Dehydrolinalool" from BASF.

- 5 Where inhibitor (D) is used, it is employed appropriately
in amounts of preferably from 0.01 to 10% by weight, more
preferably from 0.01 to 3% by weight, based on the overall
weight of the organosilicon compounds (A) and (B).
- 10 Examples of further constituents which may be used in the
crosslinkable silicone coating compositions are agents for
adjusting the release force, organic solvents, adhesion
promoters, and pigments.
- 15 Examples of agents for adjusting the release force of the
coatings, repellent to tacky substances, that are produced
with the compositions of the invention are silicone resins
comprising units of the formula
- 20 $\text{R}^7\text{R}^5_2\text{SiO}_{1/2}$ and SiO_2 ,

- known as MQ resins, where R^7 is a hydrogen atom, a
hydrocarbon radical R^5 , such as methyl radical, an alkenyl
radical R^6 , such as vinyl radical, and R^5 and R^6 are as
25 defined above, and the units of the formula $\text{R}^7\text{R}^5_2\text{SiO}_{1/2}$ may
be identical or different. The ratio of units of the
formula $\text{R}^7\text{R}^5_2\text{SiO}_{1/2}$ to units of the formula SiO_2 is
preferably from 0.6 to 2. The silicone resins are used
preferably in amounts of from 5 to 80% by weight, based
30 on the overall weight of the organosilicon compounds (A)
and (B).

- Examples of organic solvents are petroleum spirits, e.g.,
mixtures of alkanes having a boiling range of from 70°C
35 to 180°C, n-heptane, benzene, toluene and xylenes,
halogenated alkanes having from 1 to 6 carbon atoms, such

as methylene chloride, trichloroethylene and perchloroethylene, ethers, such as di-n-butyl ether, esters, such as ethyl acetate, and ketones, such as methyl ethyl ketone and cyclohexanone.

5

Where organic solvents are used, they are employed appropriately in amounts of preferably from 10 to 90% by weight, more preferably from 10 to 70% by weight, based on the overall weight of the organosilicon compounds (A) and (B).

10

Although the sequence when mixing the constituents (X), (A), (B), (C) and, where used, (D) is not critical, it has nevertheless been found appropriate for practical purposes to add constituent (C), viz the catalyst, last to the mixture of the other constituents.

15

The crosslinking of the compositions of the invention takes place preferably at from 70°C to 180°C. As energy sources for thermal crosslinking it is preferred to use ovens, e.g., forced air drying ovens, heating tunnels, heated rollers, heated plates, or heat rays from the infrared region.

20

As well as thermally, the compositions of the invention may also be crosslinked by irradiation with ultraviolet light or by irradiation with UV and IR light. As ultraviolet light it is common to use that having a wavelength of 253.7 nm. In commerce there are a large number of lamps which emit ultraviolet light having a wavelength of from 200 to 400 nm and which preferentially emit ultraviolet light having a wavelength of 253.7 nm.

25

30

The invention further provides shaped bodies produced by crosslinking the compositions of the invention.

35

The shaped bodies preferably comprise coatings, more preferably coatings which repel tacky substances.

5 The invention further provides a process for producing coatings by applying crosslinkable compositions of the invention to the surfaces that are to be coated and then crosslinking the compositions.

10 The crosslinkable compositions of the invention are used preferably for producing coatings which repel tacky substances, e.g., for producing release papers. Coatings which repel tacky substances are produced by applying crosslinkable compositions of the invention to the surfaces that are to be made repellent to tacky substances
15 and then crosslinking the compositions.

The application of the compositions of the invention to the surfaces to be coated, preferably surfaces to be made repellent to tacky substances, may be accomplished in any
20 desired manner which is suitable and widely known for the production of coatings from liquid materials; for example, by dipping, brushing, pouring, spraying, rolling, printing, by means of an offset gravure coating apparatus, for example, blade or knife coating, or by means of an
25 airbrush.

The coat thickness on the coated surfaces is preferably from 0.3 to 6 μm , with particular preference from 0.5 to 2.0 μm .

30 The surfaces to be coated, preferably surfaces to be made repellent to tacky substances, which may be treated in the context of the invention may be surfaces of any materials which are solid at room temperature and 1012 mbar (abs.).
35 Examples of surfaces of this kind are those of paper, wood, cork, and polymer films, e.g., polyethylene films

or polypropylene films, woven and nonwoven fabric of natural or synthetic fibers, ceramic articles, glass, including glass fibers, metals, polyethylene-coated paper, and boards, including those of asbestos. The
5 abovementioned polyethylene may in each case be high-pressure, medium-pressure or low-pressure polyethylene. In the case of paper the paper in question may be of a low-grade kind, such as absorbent papers, including kraft paper which is in the raw state, i.e., has not been
10 pretreated with chemicals and/or natural polymeric substances, and which has a weight of from 60 to 150 g/m², unsized papers, papers of low freeness value, mechanical papers, unglazed or uncalendered papers, papers which are smooth on one side owing to the use of a dry glazing
15 cylinder during their production, without additional complex measures, and which are therefore referred to as "machine-glazed papers", uncoated papers or papers produced from waste paper, i.e., what are known as recycled papers. The paper to be treated in accordance
20 with the invention may also of course, however, comprise high-grade paper types, such as low-absorbency papers, sized papers, papers of high freeness value, chemical papers, calendered or glazed papers, glassine papers, parchmentized papers or precoated papers. The boards as
25 well may be of high or low grade.

The compositions of the invention are suitable, for example, for producing release, backing, and interleaving papers, including interleaving papers which are employed
30 in the production of, for example, cast films or decorative films, or of foam materials, including those of polyurethane. The compositions of the invention are also suitable, for example, for producing release, backing, and interleaving cards, films, and cloths, for
35 treating the reverse sides of self-adhesive tapes or self-adhesive sheets or the written faces of self-adhesive

labels. The compositions of the invention are additionally suitable for treating packing material, such as that comprising paper, cardboard boxes, metal foils and drums, e.g., cardboard, plastic, wood or iron, which is intended
5 for storing and/or transporting tacky goods, such as adhesives, sticky foodstuffs, e.g., cakes, honey, candies, and meat; bitumen, asphalt, greased materials, and crude rubber. A further example of the application of the compositions of the invention is the treatment of carriers
10 for transferring pressure-sensitive adhesive films in the context of what is known as the transfer process.

The crosslinkable silicone coating compositions comprising the antimisting additives of the invention are especially
15 suitable for use in rapid coating systems with coating speeds of preferably from 300 to 2000 m/min, more preferably from 400 to 1500 m/min, in which the compositions of the invention are applied at high speeds to the surfaces that are to be coated.

20

The compositions of the invention are suitable for producing the self-adhesive materials joined to the release paper, both by the offline method and by the inline method.

25

In the offline method, the silicone composition is applied to the paper and crosslinked, and then, in a subsequent stage, normally after the winding of the release paper onto a roll and after the storage of the roll, an adhesive
30 film, present for example on a label face paper, is applied to the coated paper and the composite is then compressed. In the inline method the silicone composition is applied to the paper and crosslinked, the silicone coating is coated with the adhesive, the label face paper
35 is then applied to the adhesive, and the composite, finally, is compressed.

In the case of the offline method the winding speed is governed by the time needed to render the silicone coating tack-free. In the case of the inline method the process speed is governed by the time needed to render the silicone coating migration-free. With the compositions of the invention the offline method and the inline method can be operated at speeds from 300 to 2000 m/min, preferably from 400 to 1500 m/min.

1. **Preparation of the alkenyl-functional siloxane copolymers:**

Example 1:

At 25°C 683 g of an α,ω -dihydrosiloxane of average chain length Si_{225} and 7.72 g of trivinylcyclohexane are dissolved in 1036 g of toluene ($\text{C}=\text{C}/\text{SiH} = 1.74$) and with thorough stirring a quantity of a 1% strength (based on elemental platinum) solution of a platinum-1,3-divinyl-1,1,3,3-tetramethyldisiloxane complex in an α,ω -divinyldimethylpolysiloxane having a viscosity of 1000 mPa.s at 25°C (a solution of the catalyst known as the Karstedt catalyst, whose preparation is described in US 3,775,452) is added such that the solution contains 10 ppm platinum. Over the course of 4 h at 30°C the viscosity becomes very much greater until finally 3900 mm²/s (25°C) are reached. 2072 g of divinyl-terminated polydimethylsiloxane with 200 mm²/s (25°C) are added and the toluene is removed in vacuo. The resulting product has a viscosity of 7300 mm²/s (25°C).

Example 2:

At 25°C 683 g of an α,ω -dihydrosiloxane of average chain length Si_{225} and 7.72 g of trivinylcyclohexane are dissolved in 1036 g of toluene ($\text{C}=\text{C}/\text{SiH} = 1.74$) and with

thorough stirring an amount of the Karstedt catalyst described in example 1 is added such that the solution contains 10 ppm platinum. Over the course of 4 h at 30°C the viscosity becomes very much greater until finally
5 3900 mm²/s (25°C) are reached. 1036 g of trimethylsilyl-terminated polydimethylsiloxane with 9.8 mm²/s (25°C) are added and the toluene is removed in vacuo and replaced by the same amount of 1-dodecene. This gives a solution of a vinyl-functional branched siloxane polymer in 1-
10 dodecene, with a viscosity of 4380 mm²/s (25°C).

Example 3:

At 25°C 683 g of an α,ω -dihydrosiloxane of average chain
15 length Si₂₂₅ and 7.72 g of trivinylcyclohexane are dissolved in 1036 g of toluene (C=C/SiH = 1.74) and with thorough stirring an amount of the Karstedt catalyst described in example 1 is added such that the solution contains 10 ppm platinum. Over the course of 4 h at 30°C
20 the viscosity becomes very much greater until finally 3900 mm²/s (25°C) are reached. 1036 g of trimethylsilyl-terminated polydimethylsiloxane with 9.8 mm²/s (25°C) are added and the toluene is removed in vacuo. The resulting product has a viscosity of 11 600 mm²/s (25°C).

25

Example 4:

492 g of an α,ω -dihydrosiloxane of average chain length Si_{50.2} are mixed homogeneously with 24.5 g of trivinyl-
30 cyclohexane (C=C/SiH = 1.70) and 516.5 g of toluene and the mixture is activated with 3 mg of platinum, added in the form of the Karstedt catalyst solution described in example 1. The mixture is stirred at 80°C for 2 h and then 515 g of 1-dodecene are added and the toluene is removed
35 under reduced pressure. This gives a 50% strength solution of a vinyl-functional branched siloxane polymer in 1-

dodecene with a viscosity of 275 mm²/s (25°C).

Example 5:

5 492 g of an α,ω -dihydrosiloxane of average chain length
Si_{14.9} are mixed homogeneously with 80.5 g of trivinyl-
cyclohexane (C=C/SiH = 1.65) and 573 g of a trimethyl-
silyl-terminated polydimethylsiloxane of viscosity
9.8 mm²/s (25°C) and the mixture is activated with 3 mg of
10 platinum, added in the form of the Karstedt catalyst
solution described in example 1. After heating up
independently, the mixture is held at 80°C for 1 h and
then cooled. This gives a 50% strength solution of a
vinyl-functional branched siloxane polymer with a
15 viscosity of 660 mm²/s (25°C).

Example 6:

592 g of an α,ω -dihydrosiloxane of average chain length
20 Si_{14.9} are mixed with 83 g of trivinylcyclohexane (C=C/SiH
= 1.70) and the mixture is activated with 3 mg of
platinum, added in the form of the Karstedt catalyst
solution described in example 1. The reaction mixture
attains 110°C in about 3 minutes and at the same time
25 becomes considerably more viscous. Removal of volatiles
gives a clear oil with a viscosity of 9400 mm²/s at 25°C.
It contains Si-C-bonded α -olefinic double bonds, which can
be hydrosilylated.

30 **2. Use of the alkenyl-functional siloxane copolymers as
antimisting additives:**

Example 7:

35 The alkenyl-functional siloxane copolymers of the
invention are used, for reducing the formation of aerosol,

as additives in crosslinkable silicone coating systems for use in rapid coating processes.

The standard formulation used was a mixture of

5

100 parts by weight of a linear α,ω -divinyl-dimethylpolysiloxane, having a viscosity of 300 mPa·s (25°C),

3.1 parts by weight of a linear polysiloxane comprising
10 hydromethylsiloxane and dimethylsiloxane units in a molar ratio of 2 : 1 having trimethylsiloxane end units and a viscosity of 34 mPa·s (25°C),

1.25 parts by weight of a 1% strength by weight (based on elemental platinum) solution of a platinum-1,3-divinyl-
15 1,1,3,3-tetramethyldisiloxane complex in an α,ω -divinyldimethylpolysiloxane having a viscosity of 1000 mPa·s at 25°C, and

0.3 part by weight of 1-ethynylcyclohexanol.

20 The additives of the invention from the preparation examples indicated in table 1 were added to the standard formulation in the amounts specified in table 1. As a control, a standard formulation without inventive additive was used. These mixtures were used for coating paper.

25

The substrate used was paper from Ahlstrom bearing the designation Glassine Larice Tipo 325, 62 g/m². Coating was carried out on the "BMB Pilotplant" coating unit from Bachofen & Meier AG, having a 5-roll applicator unit, at
30 550 m/min. The application roller was run at 95% of the paper speed. The coating was cured in a drying oven with a length of 18 m at 160°C. This corresponds to a crosslinking time of 1.96 seconds.

35 The formation of aerosol was determined using the Dusttrak Aerosol Monitor Model 8520. Samples were taken between the

silicone application roll and the roll nip at a distance of 12 cm from the silicone application roll.

The blank aerosol value prior to the coating tests was between 0.028-0.031 mg/m³. During the coating tests, the minimum and maximum indicated aerosol levels were recorded and the average was calculated. The average aerosol levels measured during the coating tests were corrected by the blank value of 0.03 mg/m³ in order to determine the effect due purely to the antimisting additives of the invention.

10

The coating weight was determined by means of x-ray fluorescence analysis in reference to an appropriate standard.

15 Since the extent of aerosol formation is dependent among other things on the coating weight, the average calculated aerosol levels were standardized to a coating weight of 1 g/m² for the purpose of better comparability.

20 The effect of the antimisting additives of the invention on the curing of the coating system was determined immediately by means of a migration test and in parallel by means of extraction of uncrosslinked fractions in MIBK (methyl isobutyl ketone).

25 The migration is assessed according to its extent using the marks 1 to 6, mark 1 meaning no migration (complete curing), mark 3 slight and mark 6 severe migration (incomplete curing).

30 The effect of the antimisting additives of the invention on the adhesion of the coating system to the substrate was determined by means of a ruboff test. The abrasion is assessed according to its extent using the marks 1 to 6, mark 1 meaning no abrasion, mark 3 slight and mark 6 severe abrasion.

35

The test methods are described in the brochure DEHESIVE® Silicones Test Methods from Wacker-Chemie GmbH. The results are summarized in table 1.

Table 1:

Additive	Amount [%]	Misting [mg/m ³]			Average misting [mg/m ³] standardized to 1.0 g/m ²	Extract [%] in MIBK		
		min.	max.	av.		Migration	Abrasion	
Ex.2	5	0.674	1.372	0.967	0.65	1	2	3.9
Ex.1	8	0.504	0.989	0.687	0.42	1	1	5.3
-	-	19.47	30.17	24.27	16.51	1	2	3.9

The examples in comparison with the control test without additive show that the addition of the antimisting additives of the invention significantly reduces the formation of aerosol by crosslinkable silicone coating systems in rapid coating processes.

Deleterious effects on migration and substrate adhesion (abrasion) are not observed; within the bounds of measurement accuracy, the proportion of the extractable fractions is not increased.

Example 8:

At a high application weight and with certain coating formulations, aerosol may be formed even at machine speeds well below 500 m/min. The alkenyl-functional siloxane copolymers of the invention were used, for reducing the formation of aerosol, as additives in crosslinkable silicone coating systems for use in such coating processes.

The standard formulation used was a mixture of

100 parts by weight of a branched polysiloxane containing vinyltrimethylsiloxy end groups, having a viscosity of 420 mPa.s (25°C) and an iodine number of 8.0, prepared in accordance with Example 3 of US 6,034,225,
3.6 parts by weight of a linear polysiloxane comprising hydromethylsiloxane and trimethylsiloxane units in a molar ratio of 24 : 1,
1.04 parts by weight of a 1% strength by weight (based on elemental platinum) solution of a platinum-1,3-divinyl-1,1,3,3-tetramethyldisiloxane complex in an α,ω -divinyltrimethylpolysiloxane having a viscosity of 1000 mPa.s at 25°C, and
0.3 part by weight of 1-ethynylcyclohexanol.

The additives of the invention from the preparation examples indicated in table 2 were added to the standard formulation in the amounts specified in table 2. As a control, a standard formulation without inventive additive
5 was used. These mixtures were used for coating paper.

The substrate used was paper from Ahlstrom bearing the designation Glassine Larice Tipo 325, 62 g/m². Coating was carried out on the pilot coating unit from Dixon with the
10 model number 1060, having a 5-roll applicator unit, at 150 m/min. The application roller was run at 95% of the paper speed. The coating was cured in a drying oven with a length of 3 m at 140°C.

15 The formation of aerosol was determined using the Dusttrak Aerosol Monitor Model 8520. Samples were taken between the silicone application roll and the roll nip at a distance of 12 cm from the silicone application roll. Additionally, the formation of aerosol was assessed visually and
20 evaluated with the codes 1-3:

- 1 no visible aerosol formation
- 2 slightly visible aerosol formation
- 3 severe aerosol formation.

25 During the coating experiments, the maximum indicated aerosol levels were recorded. The coating weight was determined by means of X-ray fluorescence analysis in reference to an appropriate standard, and was 4 g/m².

30 Furthermore, the effect of the antimisting additives according to the invention on the curing of the coating system was determined by means of a migration test. The migration test is described in the brochure DEHESIVE®
35 Silicones Test Methods from Wacker-Chemie GmbH.

The results are summarized in table 2.

Table 2:

5	Additive	Amount of additive in %	Misting, mg/m ³ (Dusttrak)	Misting (visual)	Migration
	Example 6	2	3.5	1	1.5
	Example 5	4	4	1	1
	Example 4	4	7.5	1.5	1.5
	Example 3	5	3	1	1.5
10	Example 2	4	3.5	1.5	2
	Example 1	8	2.5	1.5	1.5
	-	-	17	3	2

The comparative experiments show that the addition of the
15 branched organosilicon compound of the invention, as
antimisting additives markedly reduces the formation of
aerosol by crosslinkable silicone coating systems in rapid
coating processes.

20 Example 9 and comparative test as per EP-A 716 115:

An important criterion for the simple usefulness of
antimisting additives in curable compositions is their
miscibility with these compositions.

25 In order to obtain reproducible results when curing on the
coating machine, it is advantageous if the additive can
be dispersed homogeneously in the desired amount in the
curable composition without unduly great effort, and forms
a clear formulation. Accordingly, 104.4 g of the standard
30 formulation from Example 7 are mixed with 10 g of each of
the additives from preparation examples 1 to 6 by moderate
stirring using a glass rod, so that a ready-to-use
formulation is formed within a few minutes. All

formulations are homogeneous, clear, and free from streaks.

For comparison, in accordance with the state of the art,
5 an antimisting additive as per EP-A 716 115 is prepared:

A mixture of 34 g of 2-methyl-3-buten-2-ol and 190 g of
an allyl polyether of the formula $\text{CH}_2=\text{CH}-\text{CH}_2\text{O}(\text{C}_2\text{H}_4\text{O})_{9.4}\text{H}$ is
mixed with 200 g of a siloxane having trimethylsiloxy end
10 groups and comprising hydromethylsiloxane and
dimethylsiloxane units (0.30% by weight active hydrogen,
viscosity 37 mm²/s at 25°C), and the mixture is heated to
50°C and activated with 20 ppm platinum in the form of the
platinum catalyst described in Example 8 (Karstedt
15 catalyst). After 2 hours, the exothermic reaction gives
a clear product with an active hydrogen content of less
than 0.002% by weight and a slight brown coloration.

Stirring 10 g of this product into 104.4 g of the standard
formulation from Example 7 gives a milky mixture which
20 shows severe phase separation after 4 hours of storage.
Even when only 5 g of this additive is mixed in under
strong shearing with a Turrax® device, a clear formulation
is not obtained.